

# Work Order ID 57887

Monday, April 19, 2010 3:35:13 PM



Page 1

Item ID: D350-636-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube LH

Start Date: 4/19/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 4/26/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: CL

Date: 10/4/20 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

0.00

100



DOCUMENT CONTROL

0.00

DC

Document Control

Memo

Photocopy blue file and type labels per PPP D350-636-011 CHG 005

51265103

AG for BG 10/04/29

B 57877

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110

0.00



Skidtubes

Skidtubes

**Memo**

0.00

Skidtubes

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details).Drill using drill Jig DT8150 &amp; DT8863.

3- Mark fwd end for cutting using Drill Jig DT 8150 &amp; DT8863 and cut as per dwg D2750.

4- drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500"

5- locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

6-Open up holes for Detail B to 0.375" (4 holes per side)and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Open up holes for ground handling and detail C to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

8-Open up holes of Detail A to 0.297" (total of 2 holes per side).

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004

A/R□□□ Aluminum Rod

□ M113207

10-Grind welds flush as per Dwg D2750

DP

BE 10/04/21

10-4-21

H 6/4/21

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

12- Scribe batch# inside per dwg D2750

10/14/21

120

QC10- Inspect visual per QSI004- ground welds

0.00

8/10/04/21

QC

Memo

0.00

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00

8/10/04/21

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

40

J

ANN  
10-4-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

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Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

1 4/24/21

W/O:		WORK ORDER CHANGES					
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Stop



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Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

0.00



Skidtubes

Skidtubes

0.00

Skidtubes

**Memo**

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)  
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)  
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750  
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R ☐☐☐ Sikaflex-291

batch: M112429

exp. date: 10-8-20

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004  
(welding instructions on sheet 8)

A/R ☐☐☐ Aluminum Rod batch: M113207

BE 10/04/22

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section (total of 4 places per side) as per  
dwg D2750

DP

10-4-22

11/04/21

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Stop



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Sequence ID/  
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DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

11- At section AJ-AJ drill out x-bolt spacer to 0.404"

12-Deburr holes

*DP 10-4-22*

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

*8/6/04/22*

Memo

0.00

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

*8/6/04/22*

Memo

0.00



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Run Start



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Stop



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Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

① 10-4-26

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 7:30 AM  
OVEN TEMPERATURE: 320°F  
FINISH TIME: 8:00 AM

⇒ 10/04/27 1 0

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

⇒ m.k 10/04/27 (1X)

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Stop

Sequence ID/  
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DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

220

0.00



HandFinish

Hand Finishing

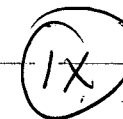
HandFinishing

Memo

1- Install inserts as per Dwg D2750

0.00

= 7 min: 12 w/04/27



230

0.00



HandFinish

Hand Finishing

HandFinishing

Memo

1-Inspect for Foreign Objects

0.00

2-Spray inside of tube with "LPS-3" batch: N/A

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: M112429

EXP DATE: 10/08

4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube

A/R 55-o-ring lube batch: M114189

5-Coat all exposed fasteners with "LPS Procyon"

batch: M104251

m-d 10/04/27



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Rev.Plan  
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QtyReject  
QtyReject  
NumberInsp.  
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/04/27

④

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10-4-2934

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

\*\*\*\*\*ensure antiseize is on AN8C21A bolts\*\*\*\*\*

8/10/05/03

④

**Dart Aerospace Ltd**

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Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-011								
	<i>HE 20</i>								
280	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

*Rev H**10-5-45**10/05/04**BS 10-5-04*

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# Picklist Print

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Page 1

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Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 4/19/2010

Required Date: 4/26/2010

Comments: IPP Rev: ☐ 02.09.25 ☐ Rearranged procedure steps ☐ KJ ☐

Start Qty: 1.00

Required Qty: 1.00

IPP Rev: J 06-03-23 As per Rev D JLM

IPP Rev: K 06-07.13 As per dsi9343 EC

IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

D2594-3

Manufactured No

230

Each

188.0000 8.0000



O-Ring, 205 Skidtube

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

55546 ✓

188

188

D2744

Manufactured No

110

Each

40.0000 1.0000



Cap

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

47488

51922

40

21

19

D2600-3-BENT

Manufactured No

110

Each

3.0000 1.0000



Extrusion Bent

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

55462

3

3

B 57538 ① n 10/4/21

8X m-d 10/04/27

1 n 12/4/21

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Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ  
IPP Rev: J 06-03-23 As per Rev D JLM  
IPP Rev: K 06-07.13 As per dsi9343 EC  
IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D2743

Manufactured No

160

Each

130.0000 8.0000



Crossbolt Spacer

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

LG

130

50281

50

52310

80

Manufactured No

160

Each

7.0000 1.0000

D2739



350 I Beam

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

LG

7

55986

1

56060

6

Manufactured No

160

Each

40.0000 4.0000

D3490-3



Cross Bolt Spacer

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

LG

40

55010

40

8 BE 10/04/22

10-4-21

4 BE 10-04-22

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Comments: IPP Rev: I ☐ 02.09.25 ☐ Rearranged procedure steps ☐ KJ ☐  
IPP Rev: J 06-03-23 As per Rev D JLM  
IPP Rev: K 06-07.13 As per dsi9343 EC  
IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3490-1

Manufactured No

160

Each

73.0000

4.0000



Cross Bolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

73

51932

8

57723

65

ALS4-1032-225

Purchased

No

220

Each

7,689.000

38.0000



Insert

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

PK011

7689

110768 ✓

7689

4 BE 10/04/22

38 x m. 10/04/27

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, April 19, 2010 3:35:12 PM

Work Order ID: 57887



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 4/19/2010

Required Date: 4/26/2010

Comments: IPP Rev: ☐ 02.09.25 ☐ Rearranged procedure steps ☐ KJ ☐

Start Qty: 1.00

Required Qty: 1.00

IPP Rev: J 06-03-23 As per Rev D JLM

IPP Rev: K 06-07-13 As per dsi9343 EC

IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

D3492-041

Manufactured No

230

Each

82.0000

8.0000



Plug Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

42

55446 ✓

42

Main Warehouse

FP031

40

57517

40

8X m-l 10/04/27

D3793-3

Manufactured No

230

Each

10.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP19

10

55458 ✓

10

1X m-l 10/04/27

AN8C35A

Purchased No

230

Each

19.0000

1.0000



BOLT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

19

110847 ✓

19

1X m-l 10/04/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Monday, April 19, 2010 3:35:12 PM

Work Order ID: 57887



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 4/19/2010

Required Date: 4/26/2010

Comments: IPP Rev: ☐ 02.09.25 ☐ Rearranged procedure steps ☐ KJ ☐  
 IPP Rev: J 06-03-23 As per Rev D JLM  
 IPP Rev: K 06-07.13 As per dsi9343 EC  
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3793-1

Manufactured No

230

Each

14.0000

1.0000



Wearshoe

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

FP18

14

51597

2

56300 ✓

12

D3488-041

Manufactured No

230

Each

34.0000

1.0000



Blade Fitting Assembly, LH

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

FP

24

47348 ✓

4

53915

20

Main Warehouse

FP007

10

56052

10

IX m-h 10/04/27

IX m-h 10/04/27

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, April 19, 2010 3:35:12 PM

Work Order ID: 57887



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 4/19/2010

Required Date: 4/26/2010

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ  
 IPP Rev: J 06-03-23 As per Rev D JLM  
 IPP Rev: K 06-07.13 As per dsi9343 EC  
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3794-3 Manufactured No 230 Each 27.0000 1.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

4

51907 ✓

4

Main Warehouse

FP18

23

56066

23

AN6C44A

Purchased No

230

Each

53.0000

4.0000



BOLT

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG

2

103964

2

Main Warehouse

ST344

51

111605 ✓

1

111649 ✓

50

1X m-h 10/04/27

4X m-h 10/04/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, April 19, 2010 3:35:13 PM

Work Order ID: 57887



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 4/19/2010

Required Date: 4/26/2010

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ

Start Qty: 1.00

Required Qty: 1.00

IPP Rev: J 06-03-23 As per Rev D JLM

IPP Rev: K 06-07.13 As per dsi9343 EC

IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

MS21083C8

Purchased

No

230

Each

50.0000

1.0000



NUT

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST303

50

113845 ✓

50

D3536-25

Manufactured

No

230

Each

10.0000

1.0000



Gasket

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

FP10

10

54479 ✓

10

D3631-1

Manufactured

No

230

Each

302.0000

8.0000



Washer

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST076

302

52693 ✓

302

1x m'd w/04/27

1x m'd 10/04/27

8x m'd w/04/27



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 57887



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 4/19/2010

Required Date: 4/26/2010

Comments: IPP Rev:I 02.09.25 Rearranged procedure steps KJ  
 IPP Rev:J 06-03-23 As per Rev D JLM  
 IPP Rev:K 06-07.13 As per dsi9343 EC  
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

Start Qty: 1.00

Required Qty: 1.00

D3791-1 Manufactured No 230 Each 18.0000 1.0000



Wearplate

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

7

55457

7

Main Warehouse

FP17

11

56299 ✓

11

AN960C10L

Purchased No

230

Each

0.0000

38.0000



washer

NAS1149C0332R

M114341

D2745

Manufactured No

230

Each

150.0000

8.0000



Bushing

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST023

150

52311 ✓

150

1x m-d 10/04/27

38x m-d 10/04/27

8x m-d 10/04/27

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, April 19, 2010 3:35:13 PM

Work Order ID: 57887



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 4/19/2010

Required Date: 4/26/2010

Comments: IPP Rev:I 02.09.25 Rearranged procedure steps KJ  
 IPP Rev:J 06-03-23 As per Rev D JLM  
 IPP Rev:K 06-07.13 As per dsi9343 EC  
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

Start Qty: 1.00

Required Qty: 1.00

AN3CSA Purchased No 230 Each 883.0000 34.0000



Bolt

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST350	500	
114330	500	
Main Warehouse		
ST351	383	
113121	53	
114056 ✓	179	
114108	51	
114181	100	

34X m-l 10/04/27

D3537-1 Manufactured No 230 Each 63.0000 3.0000



Wearpad

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
FP	9	
55465	9	
Main Warehouse		
FP17	54	
57510 ✓	54	

3X m-l 10/04/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 57887



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 4/19/2010

Required Date: 4/26/2010

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ  
 IPP Rev: J 06-03-23 As per Rev D JLM  
 IPP Rev: K 06-07-13 As per dsi9343 EC  
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

AN960C816L

Purchased No

230

Each

146.0000

1.0000



WASHER

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST348

146

110584

100

111424 ✓

46

Manufactured No

230

Each

82.0000

8.0000

D3492-043



Plug Assembly

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

FP

42

54682

42

Main Warehouse

FP013

40

57519 ✓

40

1x m-h w/04/27

8x m-h w/04/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 57887



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 4/19/2010

Required Date: 4/26/2010

Comments: IPP Rev:I 02.09.25 Rearranged procedure steps KJ  
 IPP Rev:J 06-03-23 As per Rev D JLM  
 IPP Rev:K 06-07.13 As per dsi9343 EC  
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

Start Qty: 1.00

Required Qty: 1.00

AN3C6A Purchased No 230 Each 679.0000 4.0000



BOLT

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST351

679

111982 ✓

679

NAS1611-013

Purchased No

230

Each

41.0000

8.0000



O-RING

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

FP

41

113743 ✓

41

D3535-25

Manufactured No

230

Each

16.0000

1.0000



Wearshoe

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

FP

16

56065 ✓

4

56839

12

4x m-h 10/04/27

8x m-h 10/04/27

1x m-h 10/04/27



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 57887

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ  
IPP Rev: J 06-03-23 As per Rev D JLM  
IPP Rev: K 06-07.13 As per dsi9343 EC  
IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

D3794-1

Manufactured No

230

Each

19.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

7

55459

7

Main Warehouse

FP014

12

57537 ✓

12

MS21043-6

Purchased No

230

Each

878.0000

4.0000



NUT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST301

878

112314 ✓

878

D3493-1

Manufactured No

260

Each

19.0000

2.0000



Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST224

19

47710

19

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1X m-l 10/04/27

4X m-l 10/04/27  
10-4-29 SP

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Monday, April 19, 2010 3:35:13 PM

Work Order ID: 57887



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 4/19/2010

Required Date: 4/26/2010

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ  
 IPP Rev: J 06-03-23 As per Rev D JLM  
 IPP Rev: K 06-07.13 As per dsi9343 EC  
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

MS21083C8 Purchased No 260 Each 50.0000 2.0000



NUT

10-4-29 sl

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST303

50

113845

50

2

AN8C21A Purchased No 260 Each 99.0000 2.0000



BOLT

10-4-29 sl

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST345

99

111605

49

113558

50

2

AN960C816L Purchased No 260 Each 146.0000 2.0000



WASHER

10-4-29 sl

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST348

146

110584

100

111424

46

2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Monday, April 19, 2010 3:35:13 PM

Work Order ID: 57887



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 4/19/2010

Required Date: 4/26/2010

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ  
 IPP Rev: J 06-03-23 As per Rev D JLM  
 IPP Rev: K 06-07-13 As per dsi9343 EC  
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3672-1 Manufactured No 230 Each 1,589.000 4.0000



Phenolic Washer

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST077 1589

47628 89

51674 500

52505 1000

4x m-h 10/04/27

D2741 Manufactured No 260 Each 43.0000 1.0000



Blade, 350 Skidtube

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST466 43

51931 11

55905 32

10-4-29

D3532-1 Manufactured No 260 Each 51.0000 2.0000



Spacer

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST068 51

52321 51

1

16-4-29

2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Monday, April 19, 2010 3:35:13 PM

Work Order ID: 57887



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 4/19/2010

Required Date: 4/26/2010

Comments: IPP Rev:I 02.09.25 ☐ Rearranged procedure steps ☐ KJ ☐  
IPP Rev:J 06-03-23 As per Rev D JLM  
IPP Rev:K 06-07.13 As per dsi9343 EC  
IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

Start Qty: 1.00

Required Qty: 1.00

D3672-13

Purchased

No

260

Each

920.0000

2.0000



Phenolic Washer



10-4-29SP

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST077

920

54363

920

2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8

7

6

5

4

3

2

1

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

## GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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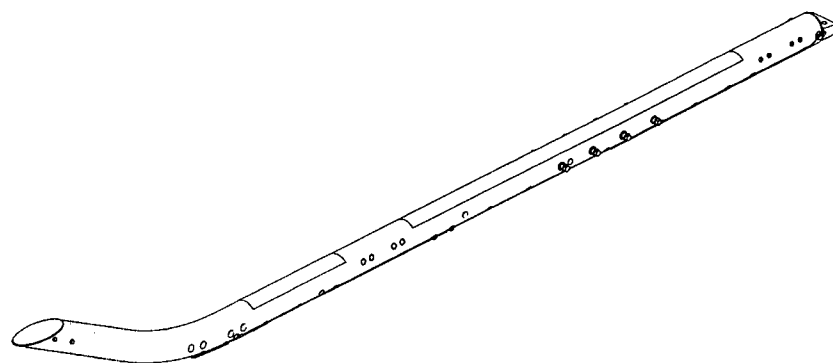
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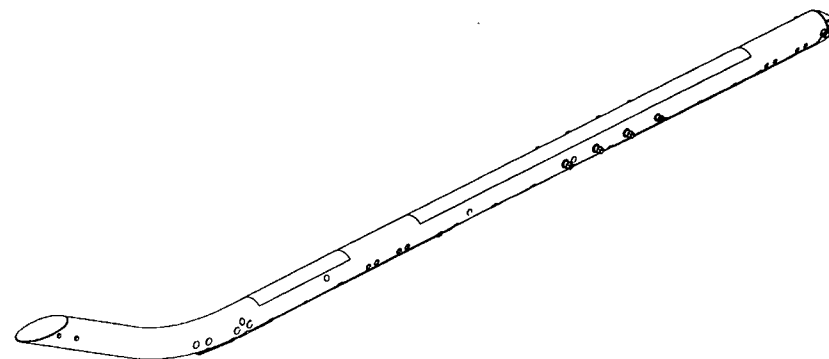
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PORT HADLOCK, WA		
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CHECKED			
MFG. APPR.			
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DATE	08.07.16		

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D2750-041 350 SKIDTUBE ASSEMBLY, LH

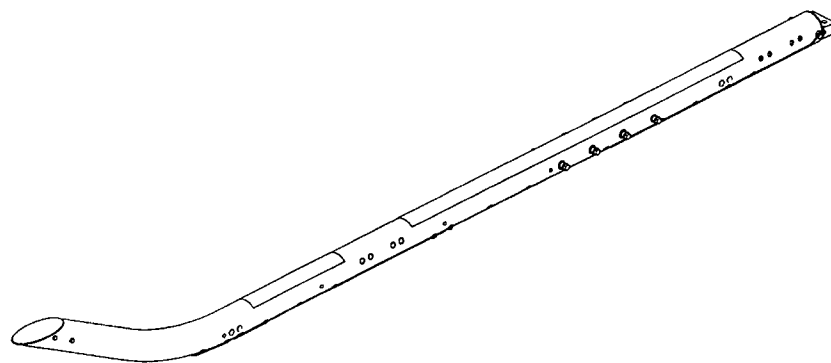


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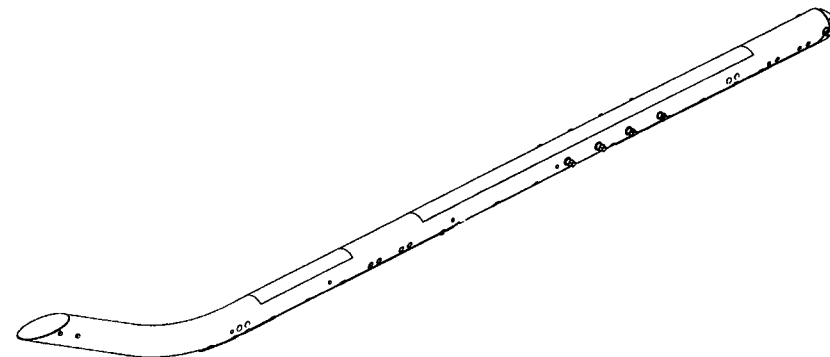
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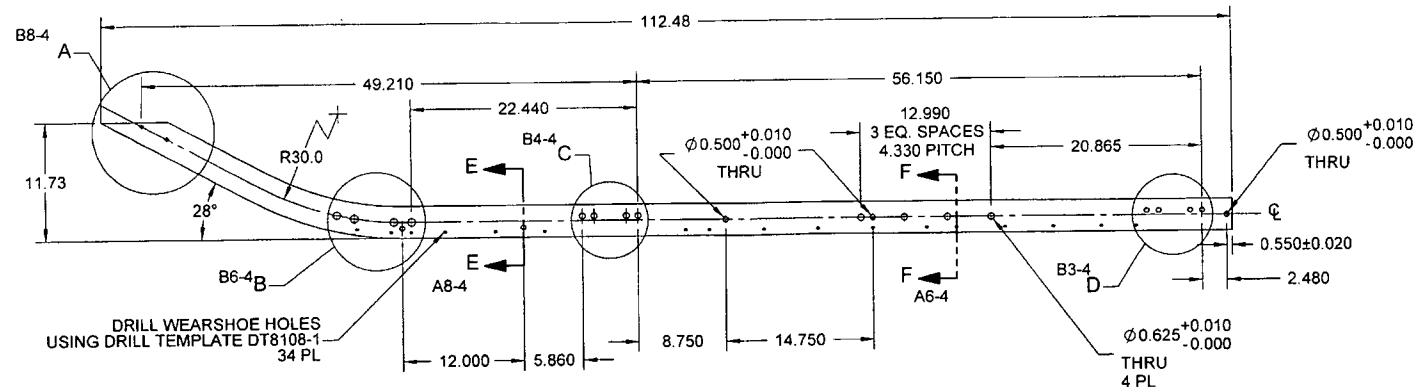
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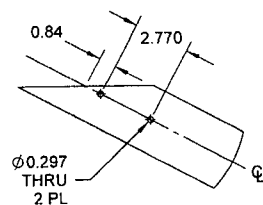
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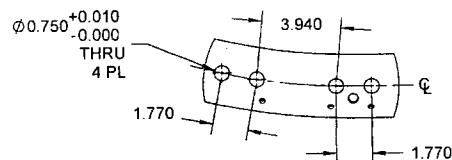


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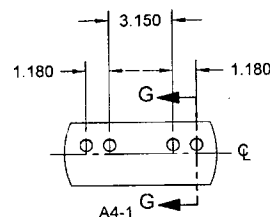
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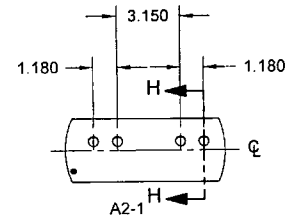
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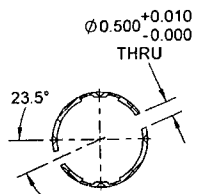
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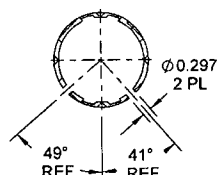
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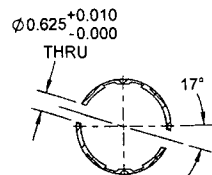
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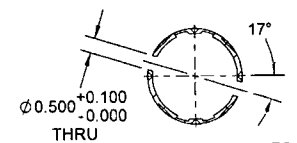
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SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL



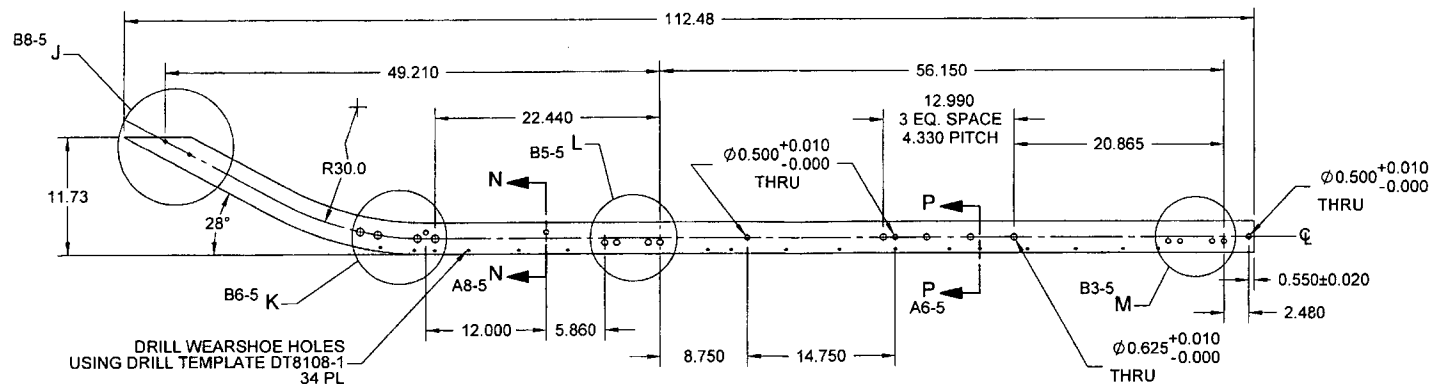
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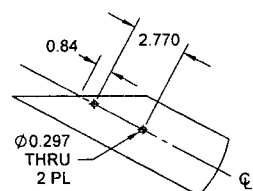
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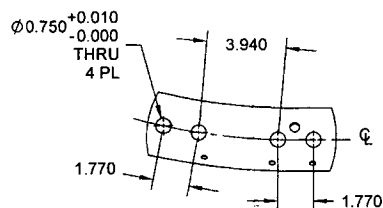
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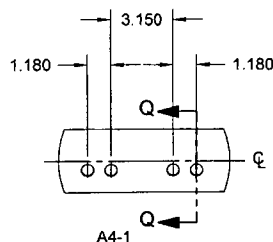
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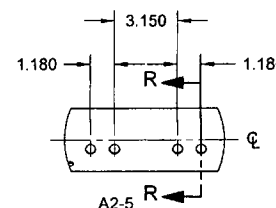
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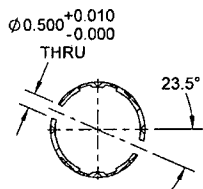
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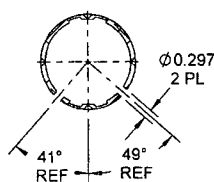
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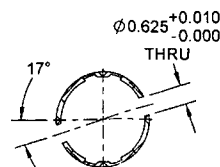
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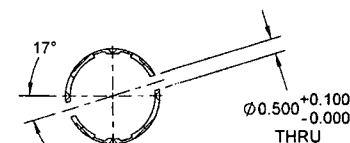
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**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
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**SECTION R-R**  
SCALE 3X, 4 PL

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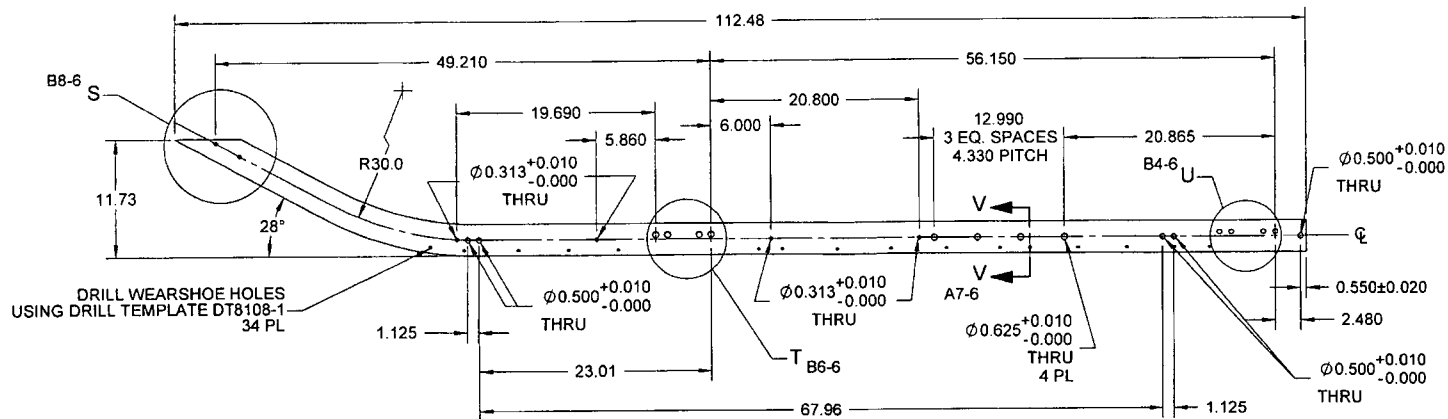
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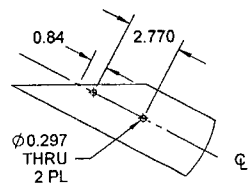
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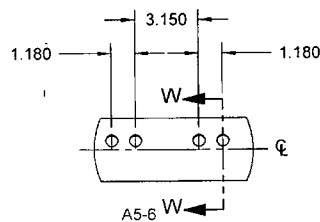
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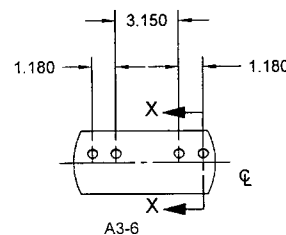
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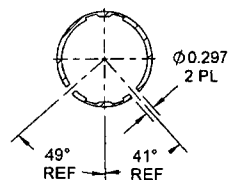
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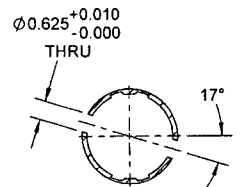
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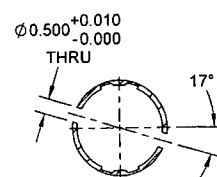
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**SECTION V-V**  
SCALE 3X, 17 PL



**SECTION W-W**  
SCALE 3X, 4 PL

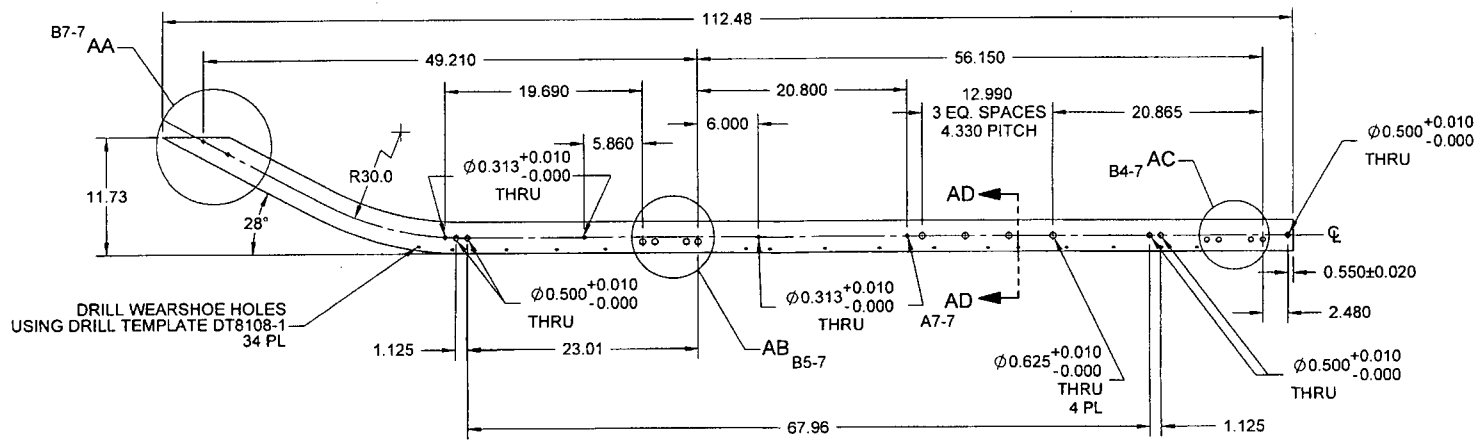


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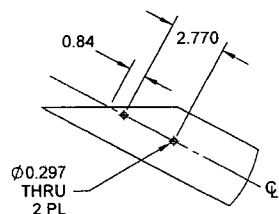
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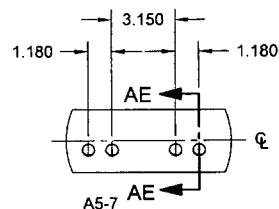
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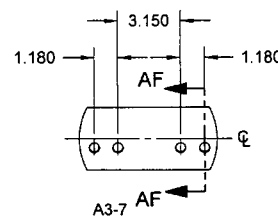
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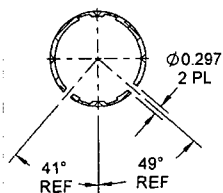
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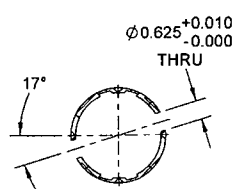
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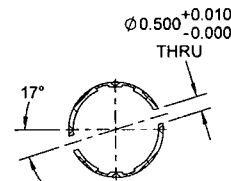
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**SECTION AD-AD**  
SCALE 3X, 17 PL



**SECTION AE-AE**  
SCALE 3X, 4 PL



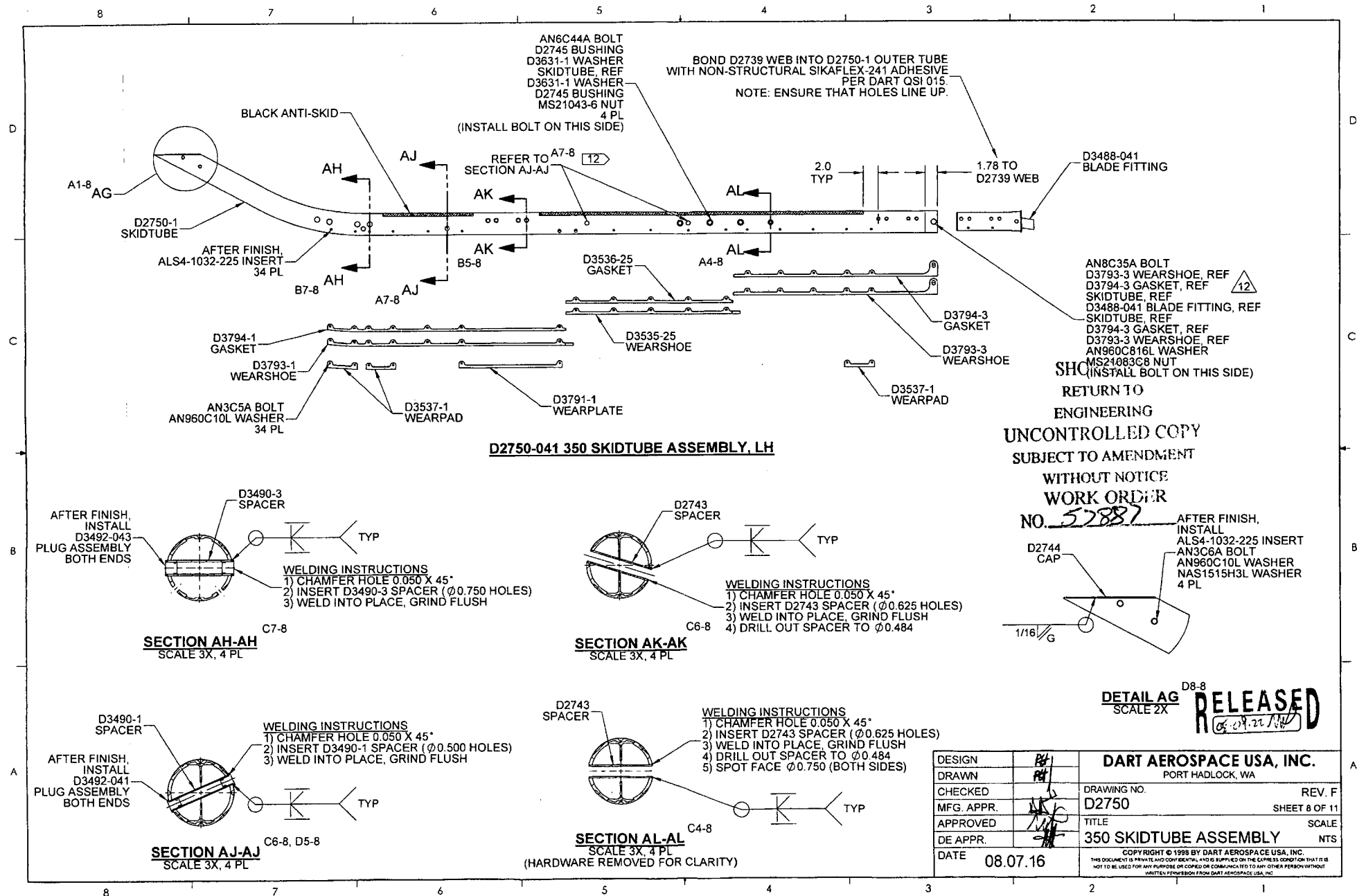
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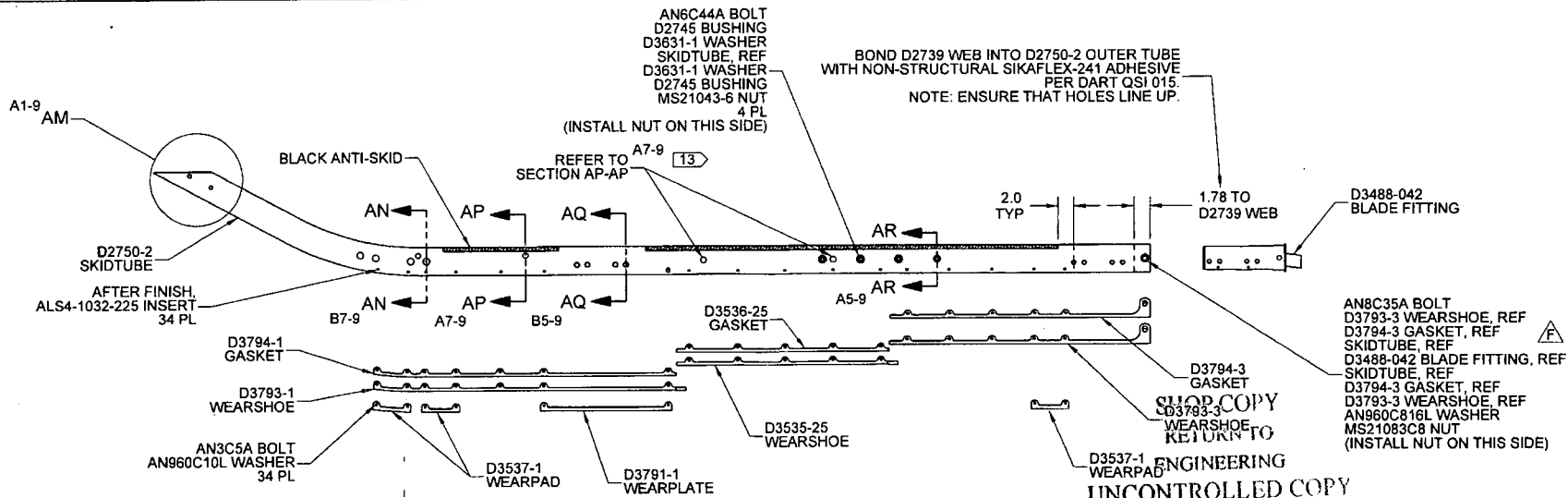
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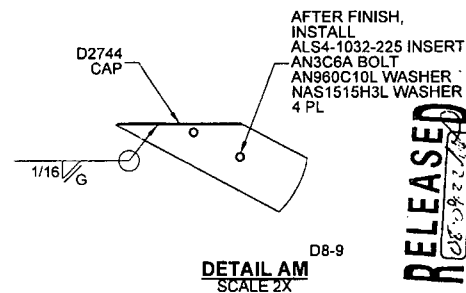
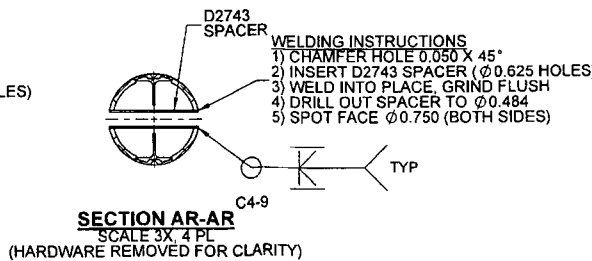
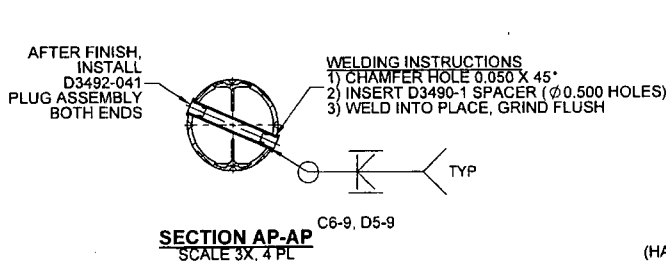
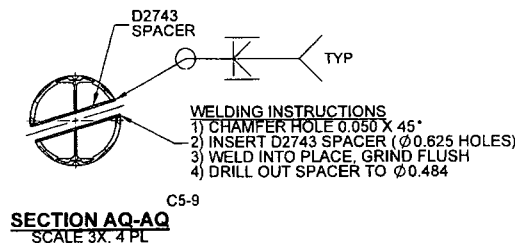
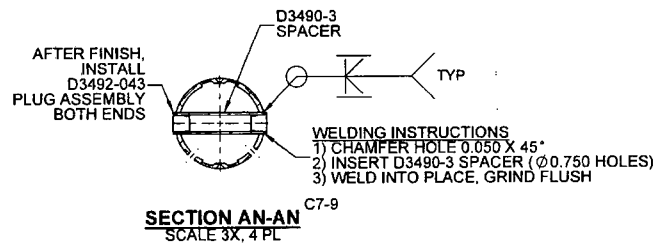


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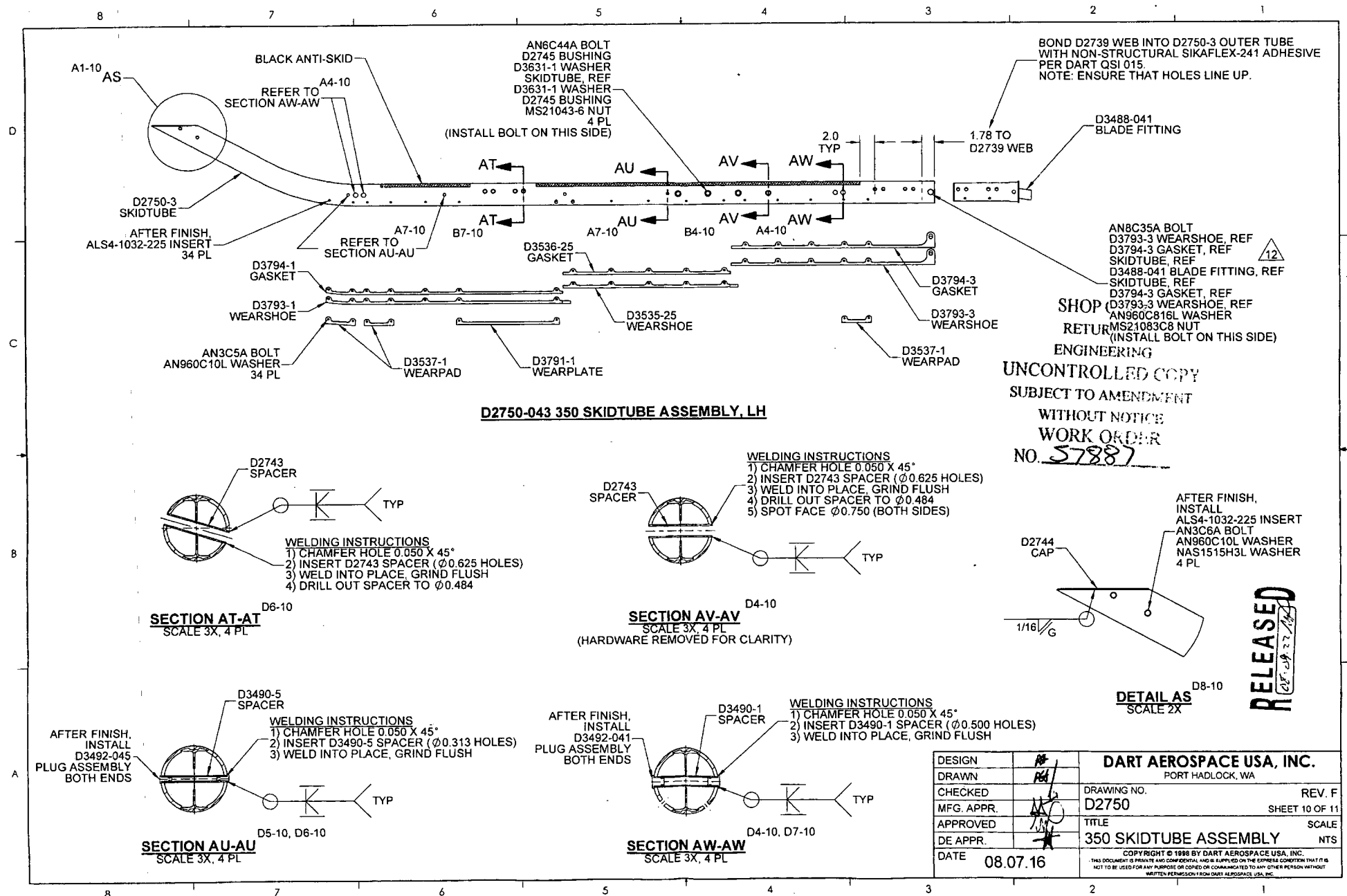
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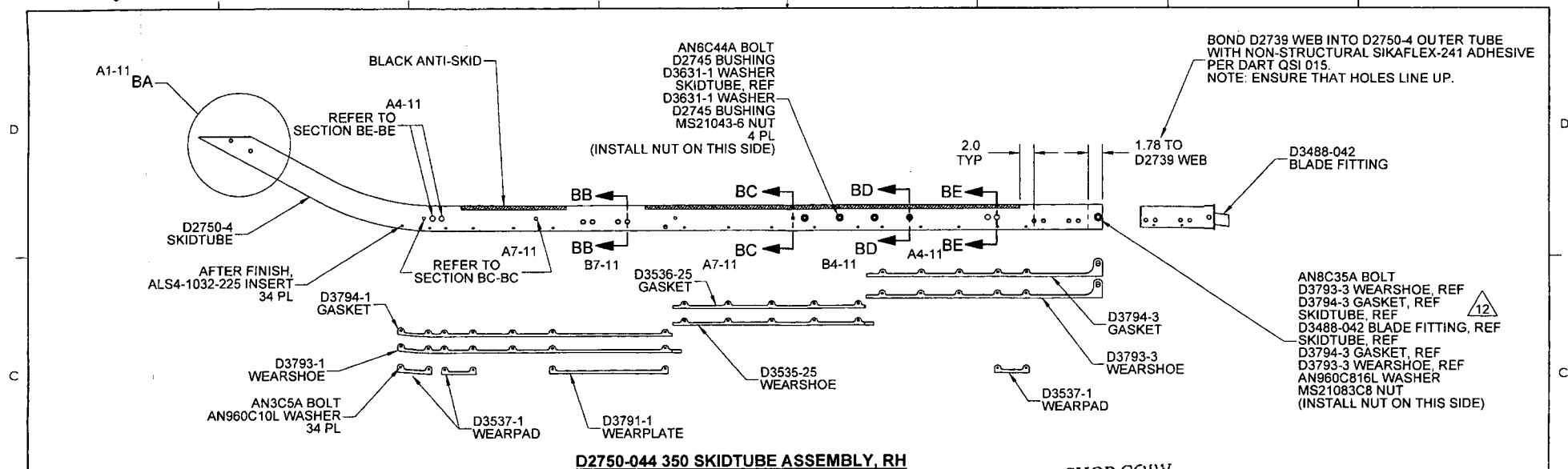


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CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 9 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND CONFIDENTIALITY IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

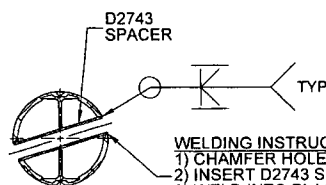
RELEASED  
2008-06-22



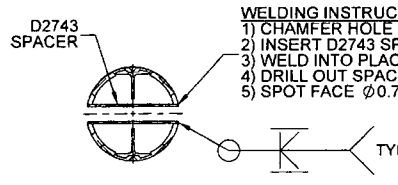
8 7 6 5 4 3 2 1



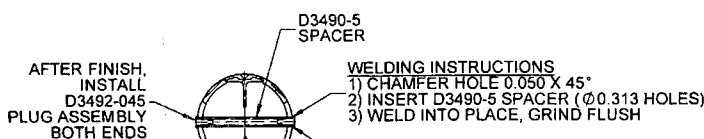
**D2750-044 350 SKIDTUBE ASSEMBLY, RH**



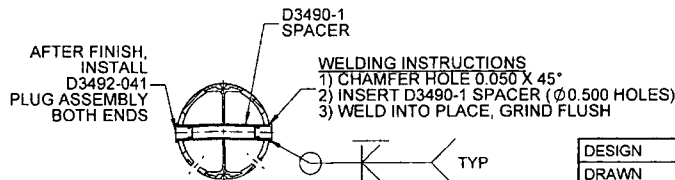
**SECTION BB-BB**  
SCALE 3X, 4 PL



**SECTION BD-BD**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)



**SECTION BC-BC**  
SCALE 3X, 4 PL



**SECTION BE-BE**  
SCALE 3X, 4 PL

SHOP COPY

RETURN TO

ENGINEERING

CONTROLLED COPY

SUBJECT TO AMENDMENT

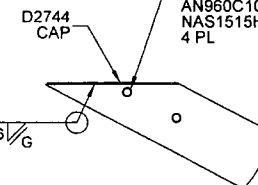
WITHOUT NOTICE

WORK ORDER

NO. 57887

**RELEASED**

AFTER FINISH,  
INSTALL  
ALS4-1032-225 IN SERT  
AN3C6A BOLT  
AN960C10L WASHER  
NAS1515H3L WASHER  
4 PL



**DETAIL BA**  
SCALE 2X

DESIGN	HA	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	HA	PORT HADLOCK, WA	
CHECKED	HA	DRAWING NO.	REV. F
MFG. APPR.	HA	D2750	SHEET 11 OF 11
APPROVED	HA	TITLE	SCALE
DE APPR.	HA	350 SKIDTUBE ASSEMBLY	NTS
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NO. 225

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 56276  
Part number: DSSC-626 CB  
Description: 350 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Pat. D. A. Date of Test Coupon 10-02-19

Welder Barclay Elliott Date of Test Coupon 10-02-19

The above named individual is qualified in accordance with AWS D17.1.2001 to weld